

Date: Wednesday, 28/05/2008 1:22:47 PM
 User: Julie Lecocq

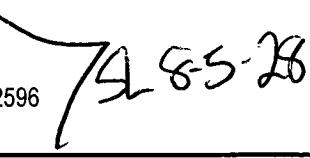
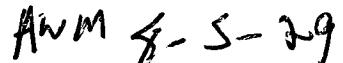
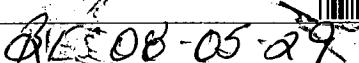
Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 205 SKIDTUBE "I" BEAM			
Job Number	: 39538						
Estimate Number	: 10346						
P.O. Number	:			Part Number	: D2596		
This Issue	: 28/05/2008	S.O. No. :		Drawing Number	: D2596 REV D		
Prsht Rev.	: NC			Project Number	: N/A		
First Issue	: / /		Type	: SKIDTUBES			
Previous Run	: 39458			Drawing Revision	: D		
Written By	:			Material	:		
Checked & Approved By	: <u>JLP</u> 08-5-28			Due Date	: 06/06/2008		
Comment	: Est: D 99.02.02 Changed QA to QC, Added Step 6 and Cost D			Qty:	5		
	M			Um:	Each		
	Est Rev:E 07-07-09 Incorporated DEO 9183 JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D25003100	Ext'n -'I' Beam Web 4"	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Extrusion "I" Beam Web 4" Pick:  Qty Part Number Description Batch 1 D2500-3-100 Extrusion 33940 SL 8-5-28			
2.0	SKIDTUBES 1	SKIDTUBES RESOURCE 1	
Comment: LANDING GEAR RESOURCE 1 1- Cut D2500-3-100 to length: 99.5" 2- Use Jig DT8093 to drill pilot holes #30 3- Open to 0.630" diameter as per Dwg D2596 4- Deburr 			
3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
Comment: HAND FINISHING RESOURCE #1 Acid Etch and Alodine per QSI 005 4.1 			
4.0	QC5	INSPECT WORK TO CURRENT STEP	
Comment: INSPECT WORK TO CURRENT STEP 			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 205 SKIDTUBE "I" BEAM

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Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

SKID TUBE CELL AWM 8-5-29

6.0 QC21

FINAL INSPECTION/W/O RELEASE



08/05/29 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

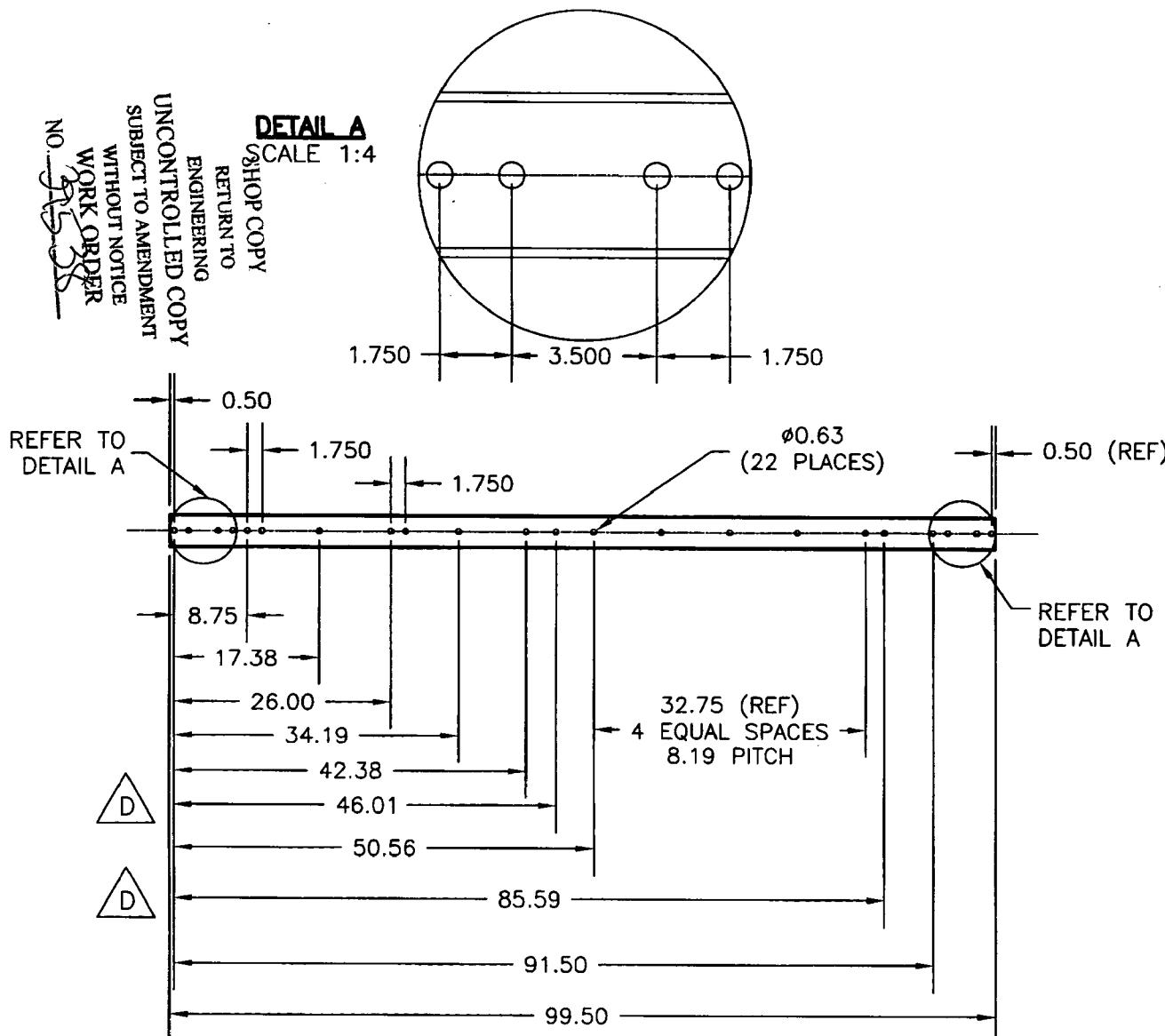
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 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**RELEASED**
07.04.17

DESIGN	DRAWN BY	DART AEROSPACE LTD
<i>PH</i>	<i>PH</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
<i>PH</i>	<i>PH</i>	D2596
DATE		REV. D
07.04.17		SHEET 1 OF 1
		SCALE
		1:20

**D2596 WEB**

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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